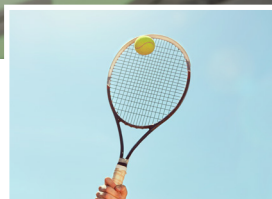
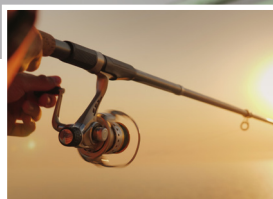




Chemlease®

MOLD RELEASE SYSTEMS | ADVANCED COMPOSITES



CHEMLEASE® ADVANCED COMPOSITES RELEASE SYSTEM

Manufacturers of advanced composite products know the importance of delivering finished parts of high structural integrity and ideal surface quality. In addition, they need to make parts efficiently and profitably. Chemlease® mold release systems help on both counts.

CHEMLEASE® BRAND PRODUCTS OFFER:

- Unparalleled priming/sealing capabilities
- Easily removable buildup
- Extremely low mold buildup
- Semi-permanent or conventional topcoats
- Virtually no transfer to part
- Water-based options

TECHNICAL DATA

For each step, choose the product that best suits your applications (see individual Product Data Sheets and Material Safety Data Sheets for specific storage, handling, and application instructions).

STEP 1: CLEAN (CHOOSE ONE)

Chemlease® Mold Cleaner EZ: A chemically aggressive, solvent-based cleaner that will remove organic materials, such as waxes, and will “freshen” surfaces coated with old semi-permanent products.

Chemlease® Mold Cleaner 1009W: A water-based cleaner effective in removing most contaminants and semi-permanent release coatings. Can also be used to prepare parts for secondary bonding or painting.

STEP 2: PRIME (CHOOSE ONE)

Chemlease® MPP 2180: For the really tough sealing jobs on extremely porous composite and metal surfaces. This product can also be used to restore the surface of worn composite tooling.

Chemlease® MPP 2737: Specifically formulated for quickly sealing low density and porous molds, masters, and plugs. Compatible substrates include but are not limited to epoxy and urethane tooling board, monolithic graphite, as well as 3D printed tooling substrates.

Chemlease® MPP C2684W: Water-based mold primer formulated for sealing and priming a wide variety of tooling substrates.

STEP 3: SEAL (CHOOSE ONE)

Chemlease® 15 Sealer EZ: For light-duty sealing of tool surfaces with microscale porosity.

Chemlease® Sealer 2739: A robust solvent-based sealer used to seal microporosity and extend the life of the release coating to allow for optimal performance.

STEP 4: TOPCOAT (CHOOSE ONE)

Chemlease® 41 EZ Series: Extremely versatile solvent-based semi-permanents that will de-mold any type of pre-preg. Dash-90 variant provides excellent slip for deep-drafted parts.

Chemlease® R&B EZ: A high-slip release agent designed for non-cosmetic parts where resin is in direct contact with the mold surface, providing multiple releases.

Chemlease® 5094W: Water-based, semi-permanent that allows for effortless release with minimal buildup on the mold.

Chemlease® 5097W: Non-silicone, water-based release agent. No cure time required. Ideal for autoclave molding and laying up with epoxy pre-pregs.

Chemlease® 2752W: Water-based, semi-permanent compatible for releasing a variety of thermoset resins. Provides minimal transfer of release agent and high temperature stability. Perfectly suited for high temperature compression molding.

Note: These are general application guidelines. Please consult your local Chemlease® representative and individual Product Data Sheets and Material Safety Data Sheets for specific storage, handling, and application instructions.

Composite Selector Guide

PRODUCT APPLICATION				
APPLICATION TYPE	NUMBER OF COATS	CURE TIME BETWEEN COATS (MINUTES)	FINAL CURE TIME PRIOR TO MOLDING (MINUTES)	

TOPCOATS - CLASS A FINISH (HIGH GLOSS)

Chemlease® 41-90 EZ	Wipe on/wipe off for high gloss	3 to 5	15	30
Chemlease® 41 EZ	Wipe on/wipe off for high gloss	3 to 5	15	30
Chemlease® 2710	Wipe on, let dry	5 to 7	15	30

TOPCOATS - NON-CLASS A FINISH

Chemlease® R&B EZ	Wipe on, let dry*	3 to 5	15	30
Chemlease® 41-90 EZ	Wipe on, let dry*	3 to 5	15	30

SPECIALTY TOPCOATS

Chemlease® 5094W	Wipe on, let dry	3 to 5	Allow to evaporate	Allow to evaporate
Chemlease® 5097W	Wipe on, let dry or spray on, let dry	3 to 5	Allow to evaporate	Allow to evaporate
Chemlease® 2751W	Wipe on, let dry or spray on, let dry	3 to 5	Allow to evaporate	30
Chemlease® 2752W	Spray on, let dry	3	Allow to evaporate	Allow to evaporate

SEALERS

Chemlease® 15 Sealer EZ	Wipe on/wipe off for high gloss	2 to 3	15	30
Chemlease® Sealer 2697	Wipe on, let dry	2 to 3	15	30
Chemlease® Sealer 2739	Wipe on/wipe off for high gloss	2 to 3	15	30

PRIMERS

Chemlease® MPP 2180	Wipe on/wipe off for high gloss	Varies based on surface roughness	30	60
Chemlease® MPP 2737	Wipe on, let dry	Varies based on surface roughness	30	60
Chemlease® MPP C2684W	Wipe on, let dry for high gloss	Varies based on surface roughness	30	60

CLEANERS

Chemlease® Mold Cleaner EZ	Wipe on, wipe off	N/A	N/A	N/A
Chemlease® Mold Cleaner 1009W	Buff on, rinse off	N/A	N/A	N/A

INTERNALS

Chemlease® IM02	Add to resin	N/A	N/A	N/A
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*Wiping off excess material will enhance part appearance **Note: When experiencing low-humidity conditions in the shop, the customer may find the need to extend the time between coats and increase the number of coats applied to the mold.**

While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty, either expressed or implied. Please refer to individual data sheets for further application, safety, and handling information.



A free sample for your specific application may be available. Contact your local sales rep today.
nasales@chemtrend.com | 800-323-7771

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